

Grey

Dart Aerospace Ltd.

Date: Thursday, 20/11/2008 3:36:12 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	N1 GEARBOX ACCESS PANEL KIT
<b>Job Number</b> :	43637		
<b>Estimate Number</b> :	12503		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3255041
<b>This Issue</b> :	20/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3255 REV B
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	42760	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JLD 08/11/21	<b>Due Date</b> :	21/12/2008
<b>Comment</b> :	Est Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM		

4 CP

Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D32551	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Batch: B44332 ✓

CP 09-02-12

2.0	D32553	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

Batch: B42489 ✓

CP 09-02-12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

(X4)

1-Weld as per Dwg D3255 \*\*\*purge weld\*\*\*

A/R SS ROD Batch: M106762

2-Grind Welds Flush

CP 09-02-12

4.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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**Comment:** VISUAL INSPECTION OF GROUND WELDS

209-2-13 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

209-2-13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:                      PAR #:            Fault Category:                                      NCR: Yes No DQA:            Date:                     

Resolution:                                      Disposition:                                      QA: N/C Closed:                      Date:                     

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:36:12 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 43637

Part Number: D3255041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109 648



(4X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20  
320 OF  
9:50

M-L 09/02/14

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/18 (4)

8.0

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Gasket

Batch:

B42490

09/03/11

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch:

M105846

09/03/11 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/11 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 44181

SS 09/03/11 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



MF 09-03-11

W/O:		ESTIMATE: 12503 WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mg	Approval QC Inspector	
090309	9.0	Add a note to scuff the powder coat at the banded section only using a light 320 grit or red scotch brile. perm change	EF	09/03/09	(4)	/	/	
			EF	09/03/11		090309	090309	

Part No: D3255-041 PAR #: N/A Fault Category: Prod/FAB ASSY <sup>model 35011</sup> NCR: Yes No DQA: D Date: 09/03/12  
 Resolution: SCIAP Disposition: SCIAP QA: N/C Closed: D Date: 09/23/12

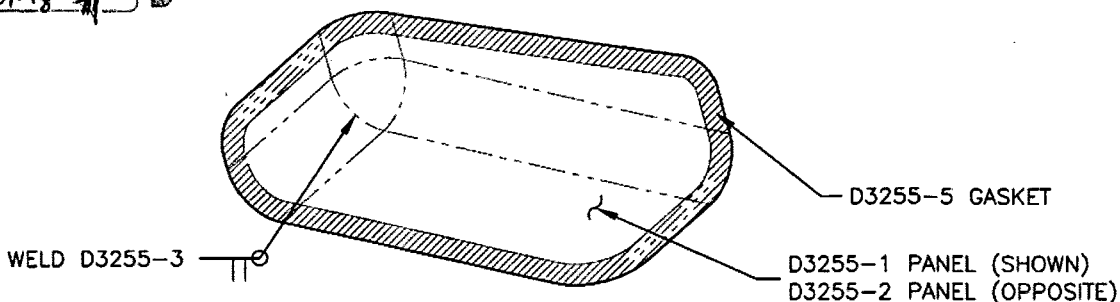
NCR: 43637		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/09	8	1 Gasket was damaged because to much glue on it R.C. process. / Stick together	/	Removed, clean part + <del>and</del> replace	EF 09/03/09	SB 09/03/09	/	/

NOTE: Date & initial all entries

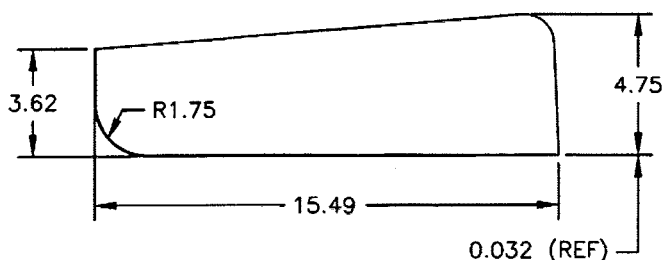
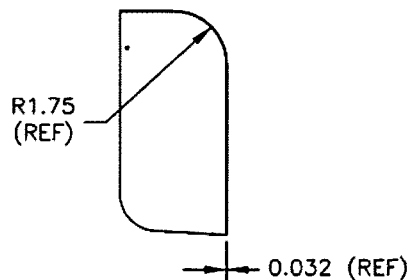
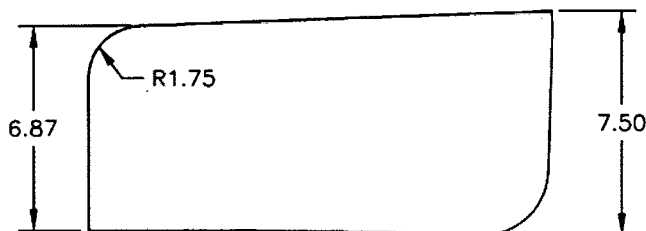


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE  
WORK ORDER  
NO. 43037

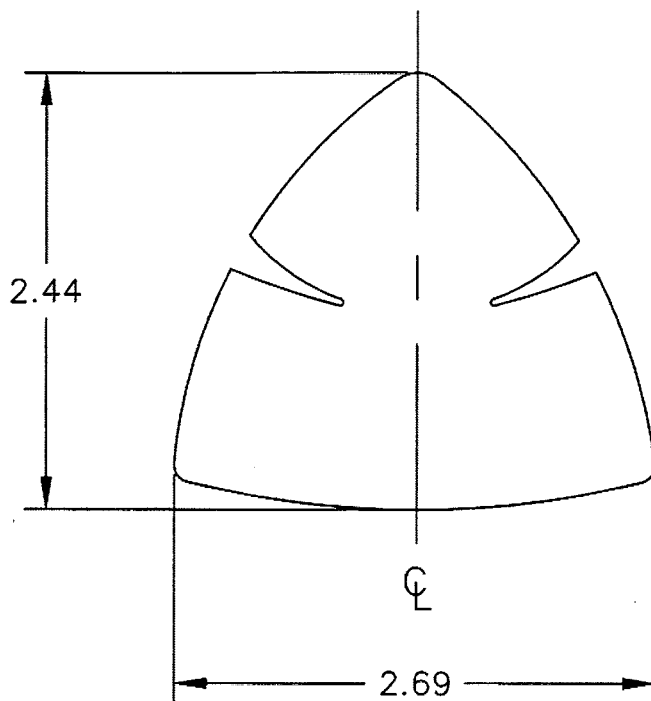
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CHECKED CP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.08 JF



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

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**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

WITHOUT NOTICE  
WORK ORDER

NO 43637

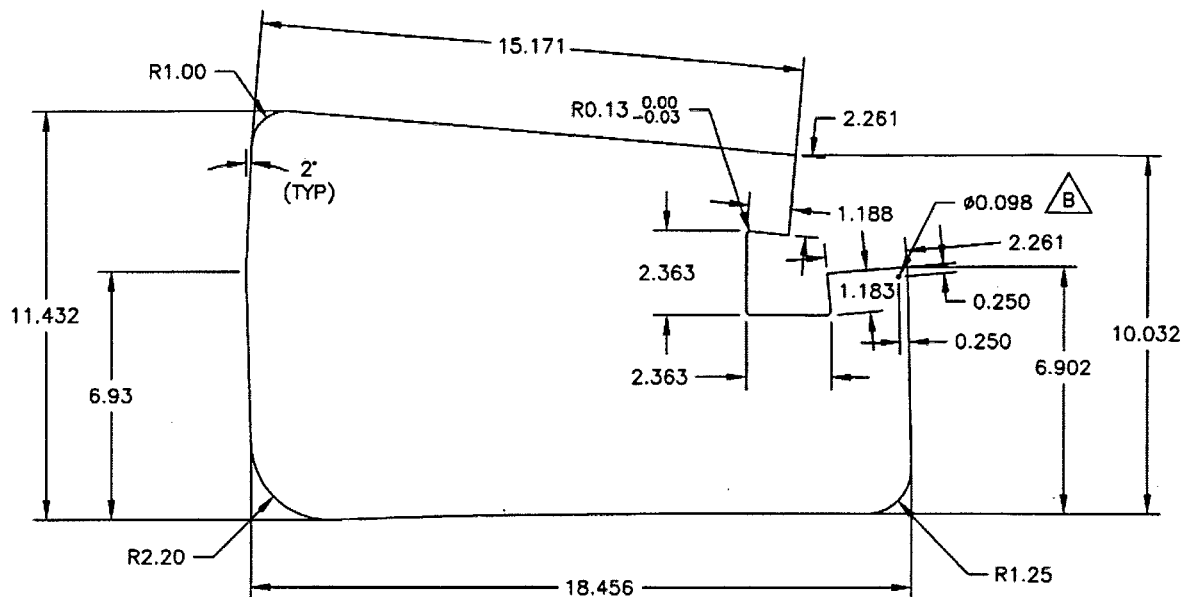
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CHECKED ip	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



**D3255-1/-2 FLAT PATTERN**

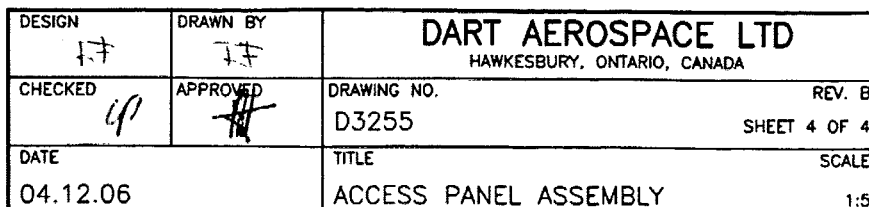
**D3255-1/-2 NOTES:**

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

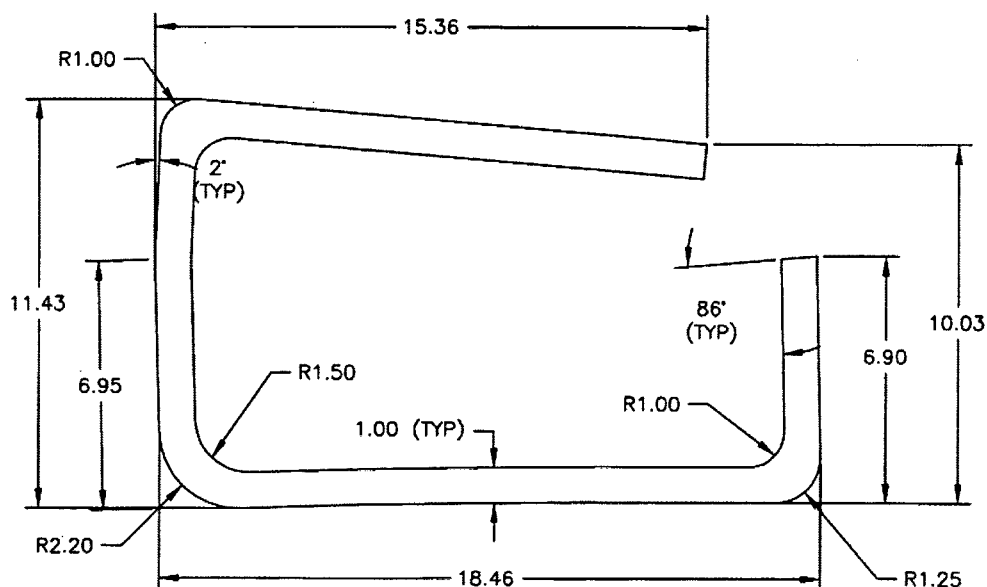
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RELEASED  
05 01 18



## D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES

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